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DPS 3.584 DPM 2509-10

PRO-SEAL 790

POLYURETHANE POTTING COMPOUND

APPLICABLE SPECIFICATION:

MIL-M-24041 A

#### INSTRUCTIONS FOR USE:

MIX RATIO: Part A : Part B = 100:32, parts by weight. Blend Part B into Part A and stir and degas

prior to use.

### PROPERTIES:

Initial Viscosity:

#7 Spindle @ 10 RPM -~90 poises

Work Life:

- >2 Hours

Cure Cycle:

8 Hours at 220°F 16 Hours at 200°F 30 Hours at 180°F

Demold Time:

-~5-6 Hours at 180°F

Hardness:

Durometer "A": 88-90

Tensile, psi:

2500

Elongation, %:

500

Tear, 1b./in:

Volume Resistivity:

 $4.4 \times 10^{11}_{12}$  OHMS CM  $4.6 \times 10^{12}$  OHMS

Surface Resistivity:

### ADDITIONAL INFORMATION:

Part A contains Isocyanate: Avoid contact with skin, eyes, and clothing. Wash with soap and water if

contact occurs.

Part B contains Amines:

Avoid contact with skin, eyes, and clothing. Wash with soap and water if

contact occurs.

ABOVE MATERIAL DOES NOT CURE AT ROOM TEMPERATURE. MUST CURE ABOVE NOT BELOW 180° F.

# $\begin{array}{c} \underline{\text{TABLE I}} \\ \text{MIL-M-24021 A} \end{array}$

## COMPARISON OF REQUIREMENTS AND PRO-SEAL 794 and 790 PROPERTIES

| RL-dIREMENT MIL-M-24041 A   | PRO-SEAL<br>794            | PRO-SEAL 790   |            |
|---|----------------------------|--|------------|
| Nonvolatile material, 99% min   | 100                        | 100  |            |
| Initial Viscosity, Type I<br>100-400 poises                                       | 180                        | 90   |            |
| Application Life, over 2 Hrs.   | >2                         | >2   |            |
| Cure Time 6 Hrs/180 deg. F/50% RH 70 "A" 7 Days/77 deg. F/50% RH 70 "A"           | 80 (5 hrs.)<br>80 (3 days) | 80 (5 hrs.)  |            |
| Ultimate Cure Time<br>16 Hrs/180 deg. F/50% RH 75 "A"<br>3 Wks/77°F/50% RH 75 "A" | 87<br>87                   | 88-90 (30 Hrs/180<br>88-90 (16 Hrs/200<br>88-90 (8 Hrs/220 | °F/50% RH) |
| Demold Time at 180°F  |                            | 5-6 Hrs.   |            |
| Specific Gravity, 1.0-1.2   | 1.09                       | 1.07   |            |
| Shore "A" Hardness, 70-92   | 87                         | 88-90  |            |
| Tensile Strength, psi 2,500 min.  | 3500                       | 2500   |            |
| U ate Elongation, % 450 min.  | 600                        | 500  |            |
| Tear Strength, lbs/in. 150 min.   | 400                        | 400  |            |
| Compression set, % 50 max.  | 30                         | .••  |            |
| Adhesion, Piw, 20 min.  | Over 20                    | -  |            |
| Moisture Absorption, % 3 max.   | 1.8                        | -  |            |
| Low Temperature, flexibility, °F-65 max.  | passes                     | passes   |            |
| Heat aging, Shore "A" loss 275°F-7 in 24 hours                                    | -                          | -  |            |
| Fungus resistance, non-nutrient   | Non-nutrient               | Non-nutrient   |            |
| Resistance to arc, Secs. 50 min   | -                          | -  |            |
| Dielectric Strength, Volts/mil 250 min.   | 550                        | 450  |            |
| Dielectric Constant 1 Kc at 77°F 10 max. 1 Megac at 77°F 8 max.                   | 5.0 (10 Kc)                | 5.1 (10 Kc)  |            |
| Power Factor 1 Kc at 77°F 0.06 max.   | 0.032 (10 Kc)              | 0.03 (10 Kc)   |            |
| Volume Resistivity n - cm - 77° F 4 x 10 <sup>11</sup> min                        | $5 \times 10^{12}$         | 4.4 x 10 <sup>11</sup>                                     |            |
| Insulation Resistance, megohms at 77°F, 300,000 min. at 250°F, 750 min.           | 500,000                    | -<br>-<br>-  |            |

| REQUIREMENT MIL-M-24041A  | PRO-SEAL<br>794    | PRO-SEAL<br>790        |
|---|--------------------|------------------------|
| Surface Resistivity, ohms at 77°F 2.4 x 10 <sup>12</sup> min.                 | $2 \times 10^{13}$ | 4.6 x 10 <sup>12</sup> |
| After conditioning<br>10 days/77°F/95% RH 1000 min.                           | -                  | -                      |
| Hydrolytic Stability Test<br>Shore A loss - 20% max.<br>120 days/160°F/95% RH | 12                 | <b>-</b>               |
| Mix Ratio (not specified)   | 100/22             | 100/32                 |

### All values are typical and are not intended for specification use.



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